

5/08

~~SP14A~~ ✓

DART AEROSPACE LTD	Work Order:	222.88
Description: Pedal Lock Cover	Part Number:	D3371-3
Dwg: D3371 Rev. A	Qty:	50
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	SA	05.01.25	50
2	MV	Cut blank: 2.00" x 2.25" x 7.370" long Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8) (M6061T6B2.000x02.250) Identify for D3371-3	SA	05.02.16	50
3	MV	Machine D3371-3 as per Folio FA486 and Dwg D3371 Identify as D3371-3	SA	05.02.16	50
4	QC2	Inspect parts as they come off the CNC machine	SA	05.02.16	50
5	QC8	Second check	SA	05.02.16	50
6	MV	Deburr	SA	05.02.16	50
7	QC5	Inspect work to Step 6	SA	05.02.28	31
8	FP	Chemical Conversion Coat as per QSI 005.4.1	SA	05.03.01	50
9	QC3	Inspect Chemical Conversion Coat	SA	05.03.01	50
10	ST	Identify and Stock	SA	05/03/01	50
11	AC	Cost / part 17.35	SA	05.03.16	50
12	DC	Close W/O 17.21 Inspect Level 21	SA	05.03.18	50

Rev	Date	Change	Revised By	Approved
A	05.01.18	New issue	KJ/JLM	

RELEASED
05.01.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

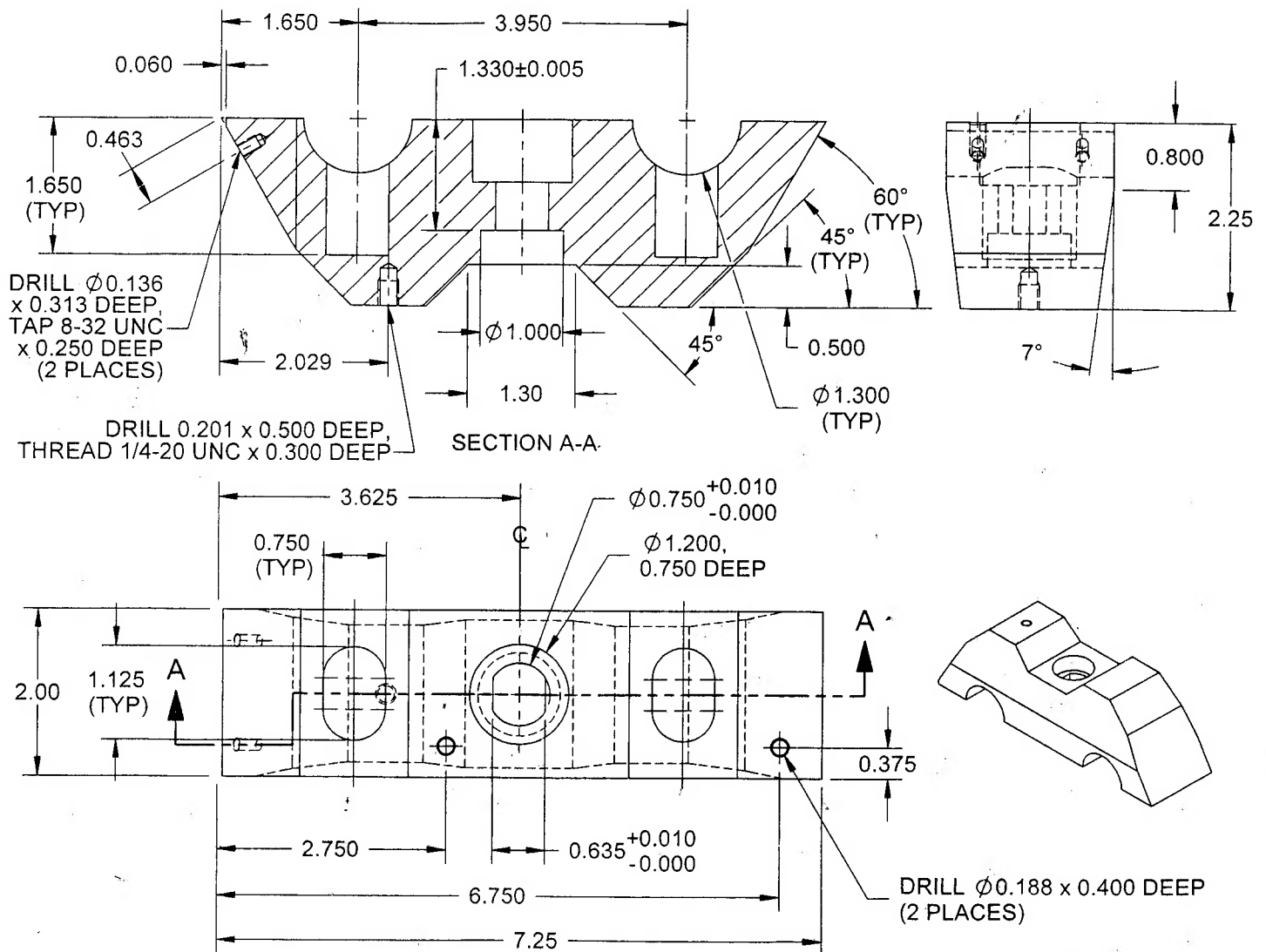
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3371	REV. A SHEET 3 OF 4
DATE 04.12.16	TITLE PEDAL LOCK		SCALE 1:2



D3371-3 COVER

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 430.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER

22288

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 25, 2005
03:20 pm

Work Order No : 0022288
Project Name : D3371-3
Project For : WK508
Work Order Type : Main
Main WO Number :
House Part Number : D3371-3
Description : Pedal Lock Cover
Manufactured : Yes
Amount Req'd : 50
Amount Done : 0
Start Date : 01-25-05
Est Finish Date : 02-20-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order: 22288
Description:		Part Number: 03371-3
Inspection Dwg:	Rev:	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.950		3.950	✓			
1.330	±.005					
60°		60°	✓			
45°		45°	✓			
.500		.504	✓			
1.30		1.300	✓			
Ø 1.000		1.000	✓			
1.650		1.660	✓			
46.3						
.060		.060	✓			
3.625		3.615	✓	NA		
Ø .750	±.000	.750	✓			
Ø 1.200		1.200	✓			
.730 Deep		.755	✓			
.375		.374	✓			
7.25	±.030	7.230	✓			
6.750		6.743	✓			
2.750		2.749	✓			
.635	±.010	.636	✓			
2.00	±.000	1.997	✓			
1.125		1.125	✓			
.750		.750	✓			

Measured by: SD	Augited by: JMC	Prototype Approval: NA
Date: 03.02.14	Date: 05/02/16	Date: NA
Rev: A	Change: New Issue	Revised by: KJ/JLM
		Approved:

verso

